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APR 19 2004
PATENT & TRADEMARK OFFICE

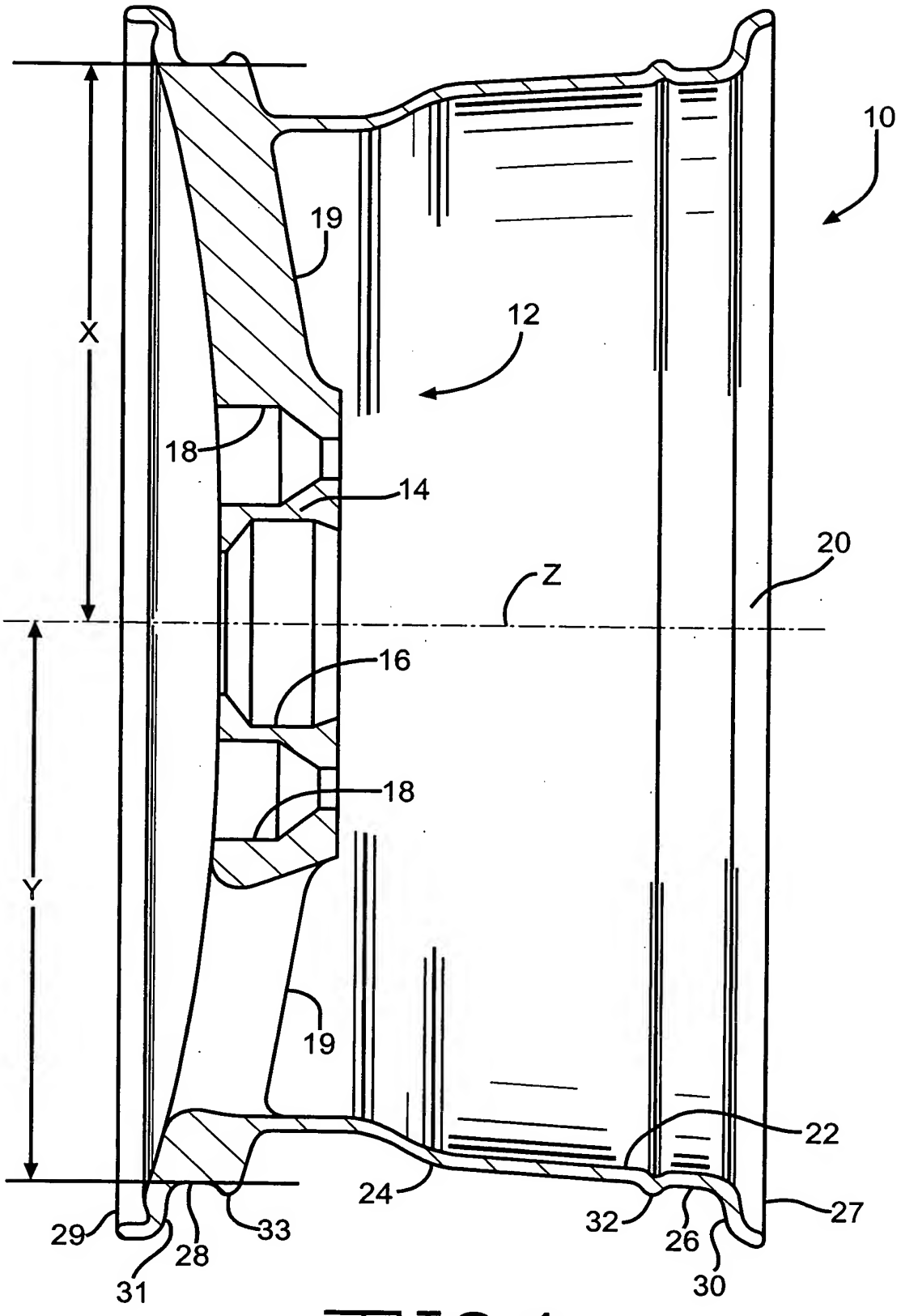

FIG. 1
PRIOR ART

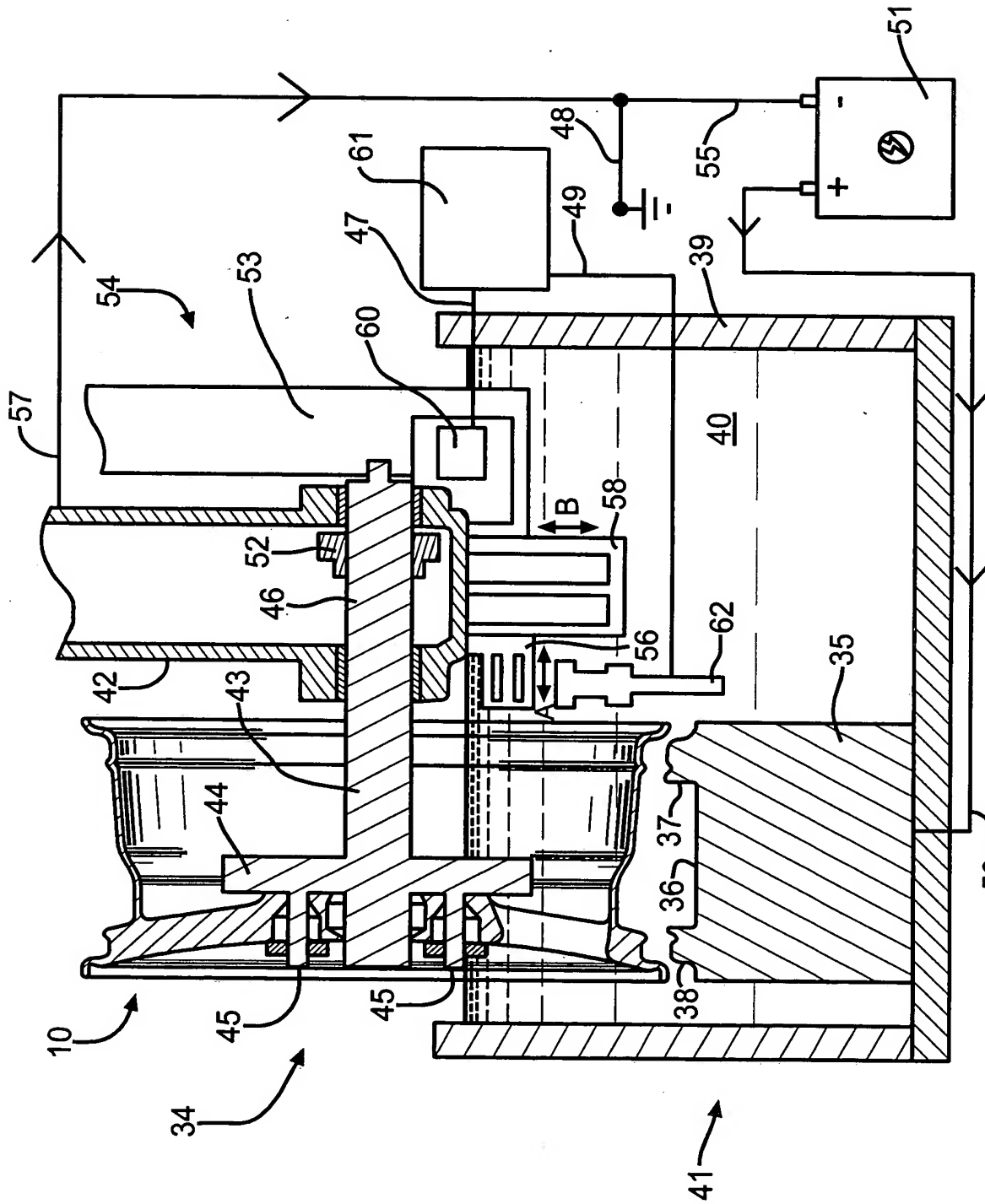
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FIG. 2

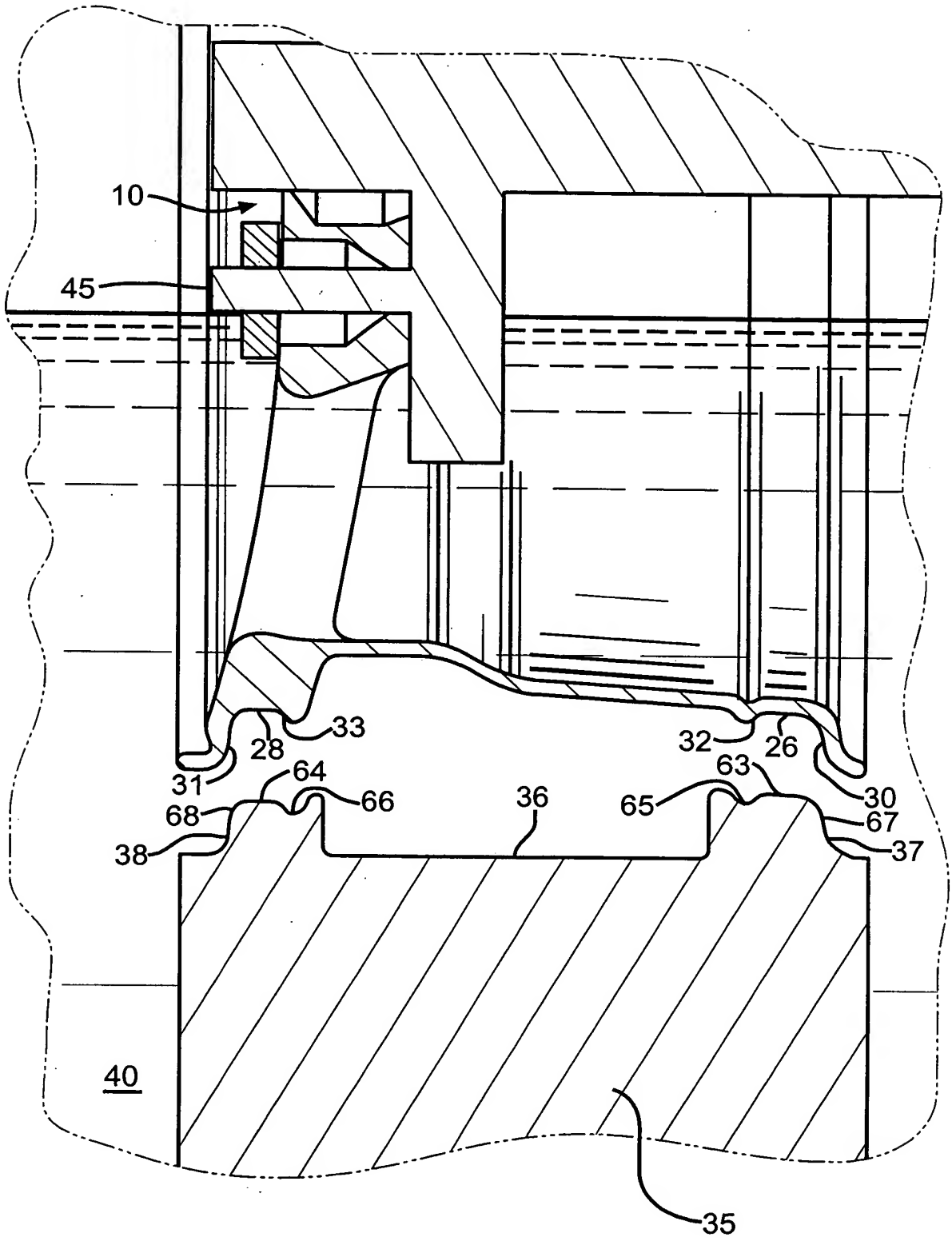
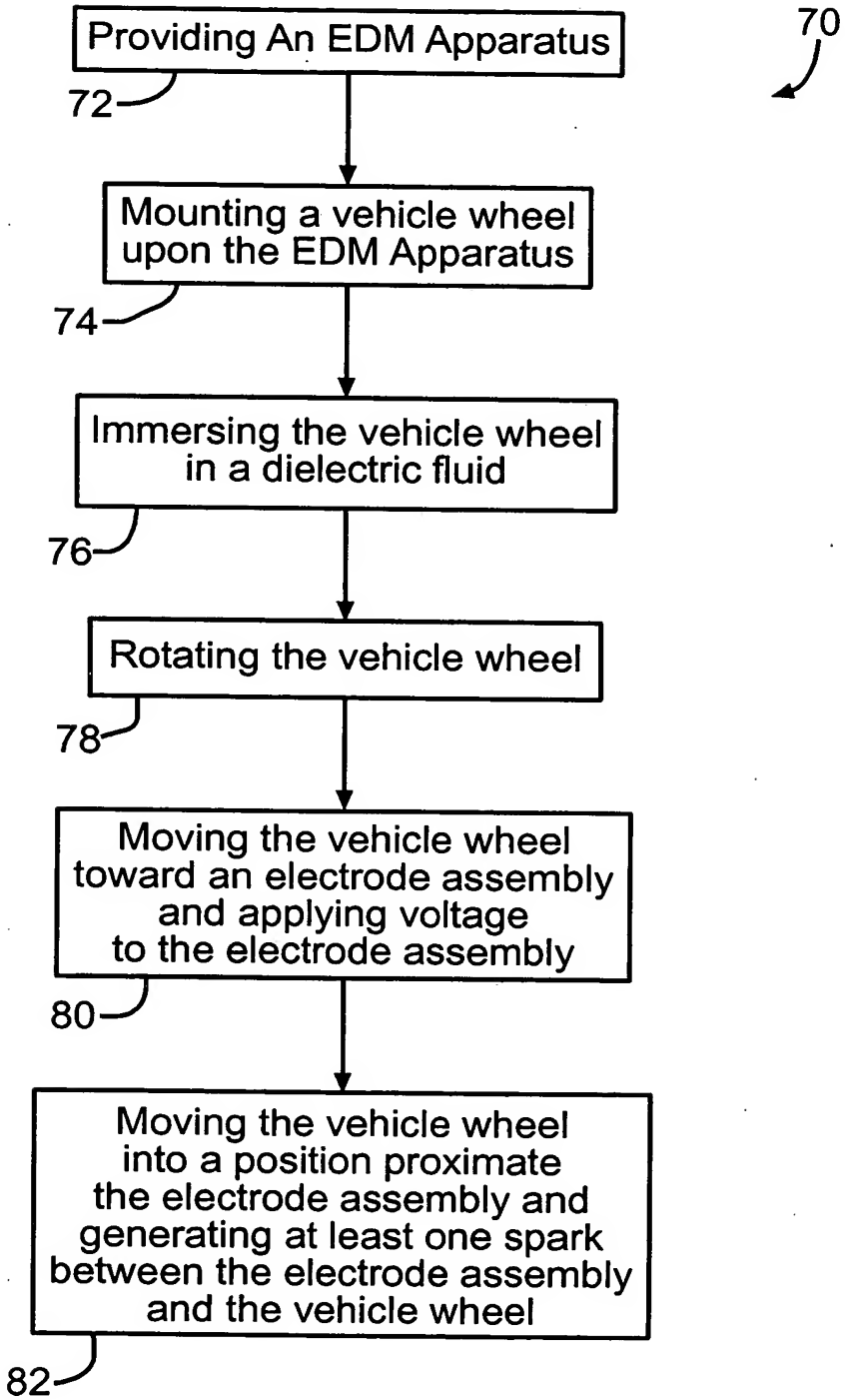


FIG. 3


Providing An EDM Apparatus
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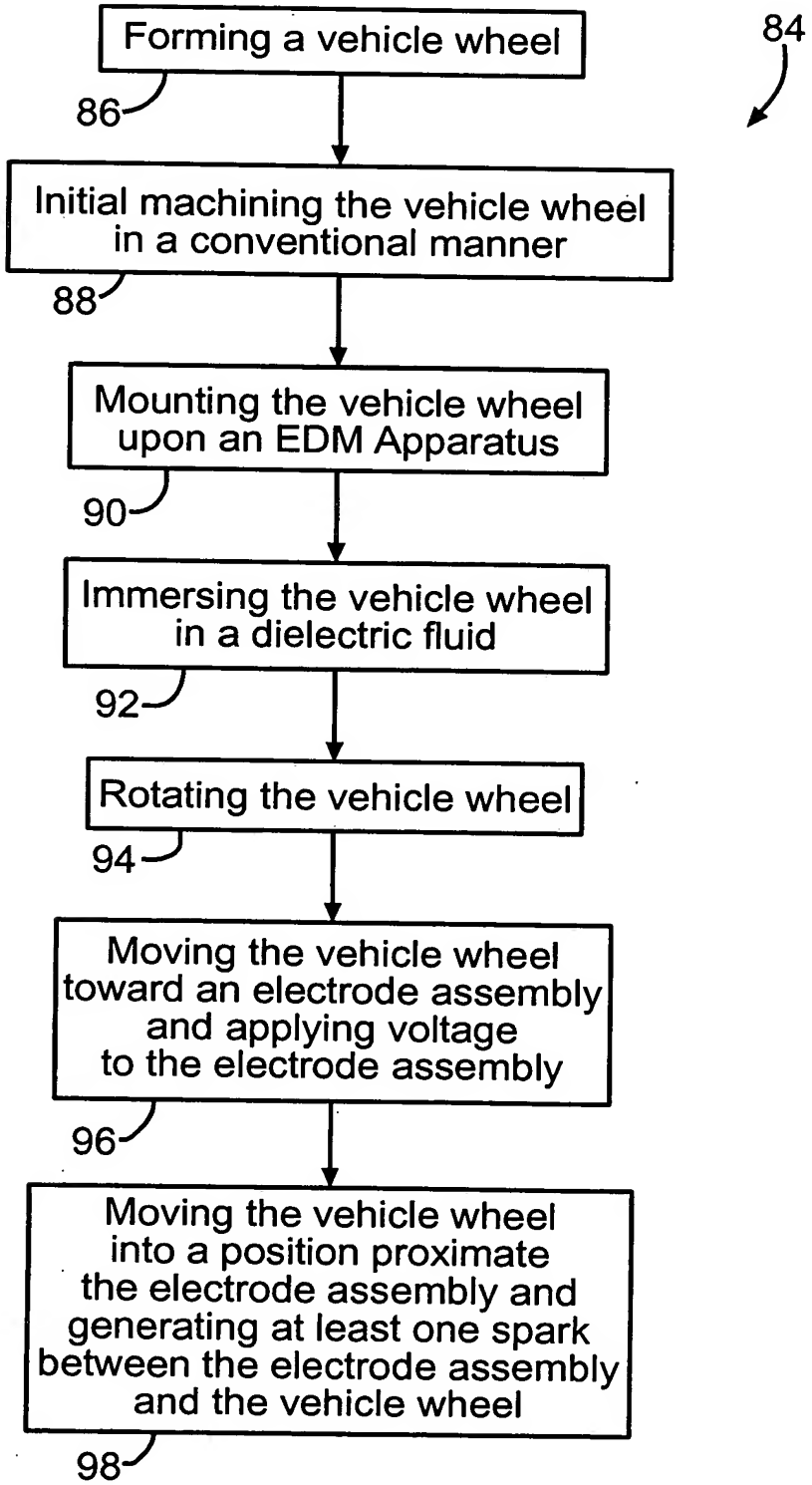
Mounting a vehicle wheel upon the EDM Apparatus
74
Immersing the vehicle wheel in a dielectric fluid
76
Rotating the vehicle wheel
78
Moving the vehicle wheel toward an electrode assembly and applying voltage to the electrode assembly
80
Moving the vehicle wheel into a position proximate the electrode assembly and generating at least one spark between the electrode assembly and the vehicle wheel
82

FIG. 4


Forming a vehicle wheel
86
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Initial machining the vehicle wheel in a conventional manner
88
Mounting the vehicle wheel upon an EDM Apparatus
90
Immersing the vehicle wheel in a dielectric fluid
92
Rotating the vehicle wheel
94
Moving the vehicle wheel toward an electrode assembly and applying voltage to the electrode assembly
96
Moving the vehicle wheel into a position proximate the electrode assembly and generating at least one spark between the electrode assembly and the vehicle wheel
98

FIG. 5